

Hardfacing FCW - High temp. fatigue and corrosion resistant

GMX410NiMo-G

Product Features:

- Gas shield type hardfacing flux cored arc welding wire.
- Martensite structure weld metal.
- Good crack resistance, high compressive abrasion resistance and good thermal fatigue resistance.

Applications:

- Hardfacing repair welding of caster guide roller.
- Build-up repair for various guide rollers.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.16	0.55	1.26	0.0	0.0	4.62	12.19	0.97

Typical characteristics of weld metal

Abrasion Resistance	Thermal fatigue Resistance	Corrosion Resistance	Welding Layer	Hardness HRC
Excellent	Excellent	Excellent	3	46-52

Size & recommended welding parameters

Diameter	1.2mm	1.6mm
Polarity	DC+	DC+
Ampere	150~320	180~340
Voltage	25~33	26~35
Wire extension	15~25mm	15~25mm
Shielding Gas	CO ₂ or Mixed Gas	CO ₂ or Mixed Gas

Note:

- All values listed on the table obtained from CO₂ shielding gas for welding test.